

* Rush * Sub Jan 13

* for flight test

Work Order ID 155126

155126

Page 1

Item ID: D5357-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut Weldment

Start Date: 01/10/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/12/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5357	B

110 Weld per dwg A/R S.S. rod Batch: 134942 0.00

110

Large Fab

Memo

0.14

Large Fab

Weld stud to strut as per dwg

GRIND WELD FLUSH

120 QC9- Inspect visual per QSI004- Fusion Welds 0.00

120

QC

Memo

0.00

Quality Control

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

1 17-01-13 JMC

1 JAN 13 2017 CAC

1 DAS 38 JAN 13 2017

155126

Page 2

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

[illegible]

155126

Monday, January 09, 2017 10:45:19 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 01/10/2017 **Start Qty:** 1.00 ***1***

Required Date: 01/12/2017 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

170

QC

Memo

0.02

Quality Control

207.1610.1

MF
17-1-13

Picklist Print

Page 1

Monday, January 09, 2017 10:45:18 AM

Work Order ID: 155126

155126

Parent Item: D5357-043

D5357-043

Parent Item Name: Strut Weldment

Start Date: 01/10/2017

Required Date: 01/12/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4794-3		Manufactured	No				Each	5.0000		2			
D4794-3									**			17-01-13	Jm
Stud													

Location	Loc Qty	Loc Code
WA001	5	
145967	5	

D5357-1		Manufactured	No				Each	0.0000		1			
D5357-1									**			17-01-13	Jm

Strut													
AN665-34R		Purchased	No		155124		Each	57.0000		2			
AN665-34R									**				
Clevis													

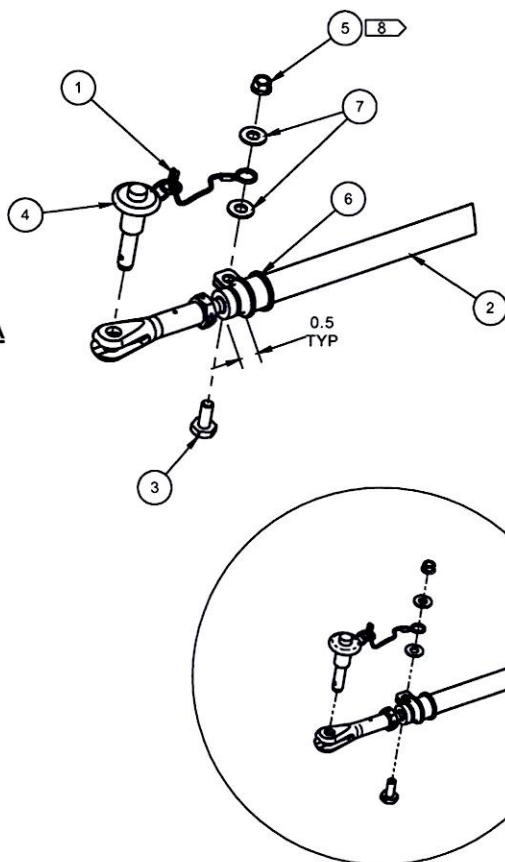
Location	Loc Qty	Loc Code
over008	47	
153852	47	
ST330	10	
M136182	10	

NAS509-4C		Purchased	No				Each	15.0000		2			
NAS509-4C									**				
NUT													

Location	Loc Qty	Loc Code
ST551	15	
M136182	7	
M136318	8	

JAN 13 2017

DETAIL A



D5357-041 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.82 lbs
- 8) TORQUE NUTS TO 20-25 in-lb

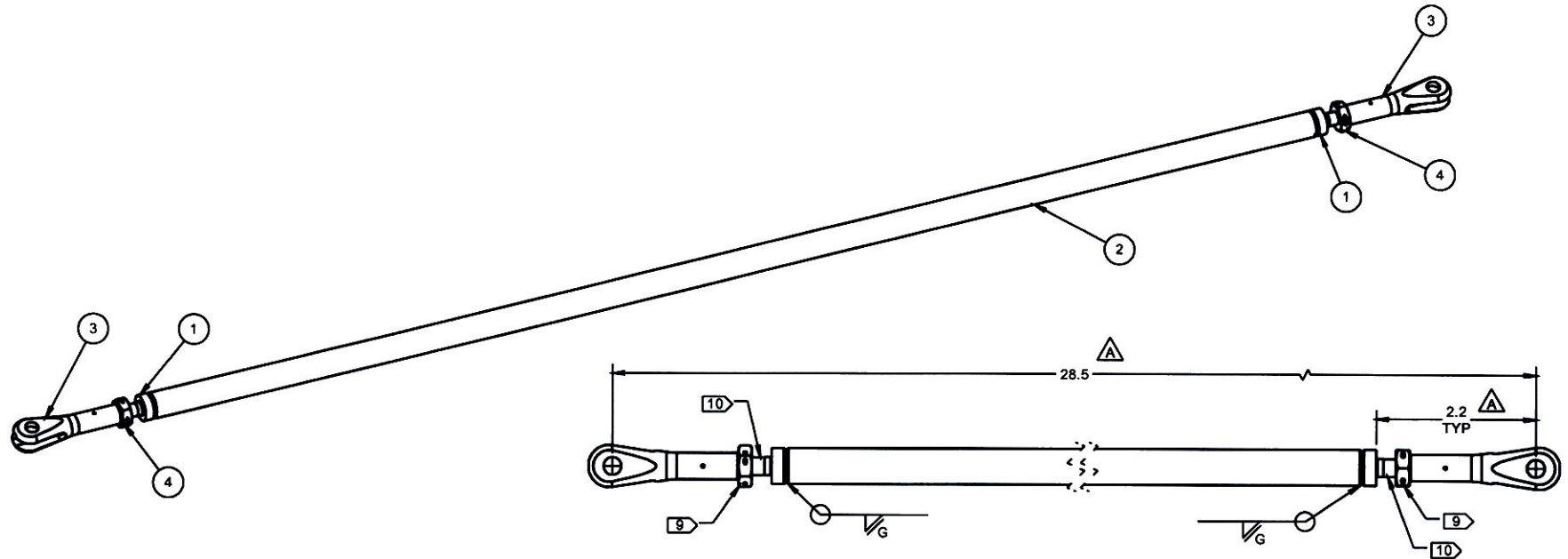
ITEM	QTY	P/N	DESCRIPTION
	X	D5357-041	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5357-043	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS17984-C405	PIN, QUICK RELEASE
5	2	MS21043-3	NUT, SELF-LOCKING
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

B	28.5 WAS 28.8, 2.2 WAS 2.3, 26.63 WAS 23.92 (ZN C3-2, B1-2, C5-3)	RF	16.12.15
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5357	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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APPROVED

w/o 155126

ITEM	QTY	P/N	DESCRIPTION
	X	D5357-043	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5357-1	STRUT
3	2	AN665-34R	THREADED CLEVIS TIE ROD
4	2	NAS509-4C	NUT, JAM



D5357-043 STRUT WELDMENT

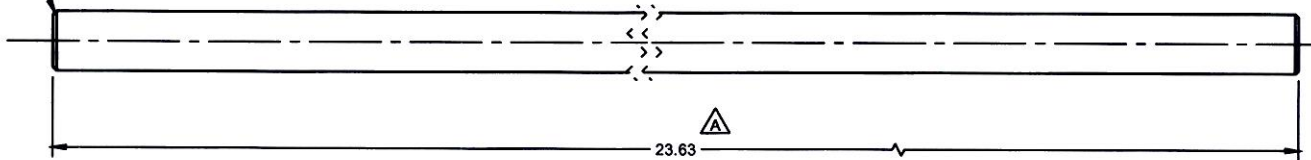
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

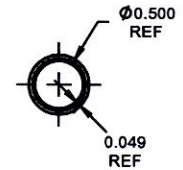
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0.030 x 45°
CMF, 2 PL



D5357-1 STRUT



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

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